Work Order June-12-13 9:14:57				*102	829*						Page 1	
Revision ID:	366 ck Handle			Accept	*N900	0040	100)* s	etup Sta	171	S1* S2*	
	1/13 Star	t Qty: 6.00 'd Qty: 6.00	*6* *6*	Sac.	Cust Item Customer:							
	-	مرح	Date: \3\06-\7 Date:	Tooling: SPC (Y/N):	· · · · · · · · · · · · · · · · · · ·	oate:	<u> </u>	R	tun Sta Sto	171	R1* R2*	
Sequence ID/ Work Center ID		ation ription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr D2366 100 *100* CNC Waterjet 304,840 110 *110* QC Quality Control		V WATER JET Memo 1-Cut as pe Deburr if no	r Dwg 2366 Dwg Rev:ecessary	0.00 0.00 Prog Rev: 0.00 0.00	2-		<u>-</u>		. 0		JMB-07-29	
120 *170* QC Quality Control	QC8-	Inspect parts - sec Memo	cond check	0.00 3	36			6		-	- - ::	

and the second of the second o

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE							"DART		
QA Closed:			Date:					0147-01	WINAITOL / OI	DATE	W	ork Order up	date only		AEROSPACE
Work Ord	or:					DISPOSITION AGAINST DEPARTMENT/PROCESS									
	Part No.				Rework Scrap			Skid-tube Crosstube Machining Small Fab		\vdash	Water Jet Prod. Eng. Coor.			Engineering .	
NCR I						Use-as-is Suspected Unapproved			noforming Large Fab	Finishing Composite			re/Packaging Supplier	\vdash	Other
Root					Desc	ription of work order update		Initial	Acti	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Cł	nief Eng	Descri	iption		Date	Verificatio	n	QC Inspector
Design															
Doc/Data															
Equip/Tooling]												ł	
Handling/Pre	L	1												ļ	
Material		1													
Operator	_											ļ			
Offset/Setup	<u> </u>											l I	ŧ	1	
Process	_													,	
Supplier	<u> </u>														
Training															
Transport	L												•		
Unapproved		<u>l</u>	1		L										<u> </u>
_	_						FΑ	ULT CAT	regory				<u> </u>		
Landi	ng (7			_	General	_	7				1		_	•
	<u> </u>	Bending			_	Bend		-1	rogram			Outside Dim			Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric		BOM/Route	_	Grain			L	Over/Under	tolerance	\sqcup	Set-up
	_	Cracks			\vdash	Broken/Damage/Defect	_	Hardwa				Part Incorred	ot .	\sqcup	Temperature/Cure
•		Crimp/Kir	nk/Ripple,	/Wave	ļ	Burrs	L	Inspecti	on Incomplete/Un	qualified	_	Part Lost/Mi	ssing	Ш	Weld
	_	Cuffs				Contamination	L	4	ions Incomplete/U	nclear	oxdot	Part Moved		\sqcup	Wrong Stock Pulled
	<u> </u>	Crushing				Countersink		Misalig	ned/off center			Positioned V	/rong		•
		Heat Trea			<u> </u>	Cut Too Short	_	Mislabe	led			Power Loss/	Surge		Other
	_	Inspection	n Strip in	Tube		Drawing	L	Misread	i						
	_	Marks/Ch	atter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of 0	Calibration						
		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	equence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Orde June-12-13 9:14		102829			Page 2				
Revision ID: tem Name:	D2366 Lock Hand 6/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	Accept	*N9000 Cust Item ID Customer:			etup Start Stop	*NS1* *NS2*
Approvals:	Process	Plan:	Date:	. •	Date		R	un Start Stop	*NR1*
	QC:		Date:	SPC (Y/N):	Date	e:		2.15	*NR2*
Sequence ID/ Work Center IE)	Operation Description	- · - · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp
130		Small Fab		0.00			6	ale	313.731
120 Small Fab		Memo		0.00	I		6		71010
Small Fab		Tumble and	stock						
140		Identify as per dwg & Sto	ck Location: 57009	0.00	•				0
140 Packaging		Memo		0.00			6x	- M. K	D. 13-08-6
Packaging									
150		QC21- Final Inspection -	Work Order Release	0.00					
150		Memo		0.00			<i>M</i>		F6-80-
Quality Control								mc=	5 13-08-06

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE							~DART
QA Closed:			Date:			WORK ORDER NON-	-C(DINFUI	RIVIAINCE / UPI		ork Order up	date only	AEROSPACE
Work Orde	ır.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N						Rework Scrap		ļ	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	- 10					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Desc	ription of work order update		Initial	Actio	n	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ct	nief Eng	Descrip	tion	Date	Verification	n QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved			•										
		-					FA	ULT CAT	EGORY				
Landir [ar ending			Γ	General Bend	Γ.	Folio/P	rogram		Outside Dim	onsions [Pressure/Forced
ŀ			ot Concer	ntric		BOM/Route	_	Grain	rogram		Over/Under	· · · · · · · · · · · · · · · · · · ·	Set-up
Ì	 	racks				Broken/Damage/Defect	 	Hardwa	re		Part Incorrec		Temperature/Cure
	c	rimp/Kir	ık/Ripple,	/Wave		Burrs		1	on Incomplete/Unqu	ualified —	Part Lost/Mi	ŀ	Weld
	c	uffs				Contamination		1	ions Incomplete/Un	 	Part Moved		Wrong Stock Pulled
	С	rushing				Countersink		Misalig	ned/off center		Positioned W	rong/	
	П	eat Trea	t			Cut Too Short		Mislabe			Power Loss/S		Other
	lr	rspection	Strip in	Tube		Drawing		Misread	I	_	<u> </u>	- [
	N	1arks/Ch	atter			Drill Holes		Off-set			· · · · · · · · · · · · · · · · · · ·	.	
Ī		urning \$	equence			Finish	Г	Out of C	Calibration			-	
ľ			ist in Tub	e		Fit/Function		Out of s	enuence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order ID:

102829

Parent Item:

D2366

Parent Item Name:

Lock Handle

Comments:

B00.05.04ReformatEC IPP

IPP Rev:C Now on Waterjet 07-04-20 JLM

Start Date: 6/11/13

Required Date: 6/11/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M304S20GA 304/316 .040 Sheet		Purchased	No			100	st	480.8986	0.0174	0.1098948 		Jo 13-0
				Location MAT020		<u>Loc Otv</u> 480.89861	<u>Lo</u>	oc Code				
				12	4029 4956 125754	117.15 96.34861 267.4			124	956		

DQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:		Date:			WORK ORDER NON-	-C(JINFOI	RIVIAINCE / UPDA		ork Or <u>der</u> up	odate only	AEROSPACE	
)		·	. =.		DISPOSITION			AC	/PROCESS	-			
Work Orde	er:				Rework Skid-tube Crosstul			osstube	1	Engineering	ļ		
Part N	lo.				Scrap				mall Fab	Pro	Water Jet d. Eng. Coor.	Quality	
T ditti	···	<u> </u>		_	Use-as-is			~ ~~	inishing	4	re/Packaging	Other	,
NCR N	۱o.				Suspected Unapproved		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Ŭ ⊢	mposite	1	Supplier	1	
										•			
Root				Desci	ription of work order update	1	nitial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector	_
Design			}									,	
Doc/Data		1										ł	
Equip/Tooling													
Handling/Pre			1			İ							
Material			ļ										
Operator					i	1							
Offset/Setup													
Process													
Supplier				-									
Training				<i>:</i>									
Transport													
Uпарргоved		ļ											_
						FAI	ULT CA	TEGORY					
Landi	ng Gear				General		_			_		_	
	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
	Centre N	ot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ct	Temperature/Cure	
	Crimp/Kii	nk/Ripple	e/Wave		Burrs		Inspect	ioπ Incomplete/Unqualif	fied	Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear	ar 🗀	Part Moved		Wrong Stock Pulled	
	Crushing Countersink		Countersink		Misalig	gned/off center		Positioned V	Vrong	_			
	Heat Trea	ət	Cut Too Short Mislabeled Power Loss/Surge		Surge	Other							
	Inspectio	n Strip in	Tube		Drawing		Misread	t					
į	Marks/Ch	natter			Drill Holes		Off-set					_	
	Turning S	equence			Finish		Out of Calibration				_		
	Wave/Twist in Tube Fit/Function				Out of S	Sequence							

DART AEROSPACE LTD	Work Order:	102829
Description: Lock Handle	Part Number:	D2366
Inspection Dwg: D2366 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	0.192	•	:	V	Jhnoi
0.750	+/-0.010	0,754"	1		V	
0.344	+/-0.010	0.347	•		V	
1.196	+/-0.010	1.196	•		V	
2.750	+/-0.010	1.196"	,		V	
	<u>.</u>				-	
	7	,				
						
			· _			
				-		
				·		
			Oğu			

Measured by: Jm Audited by: Prototype Approval: N/A

Date: 13-07-25 Date: 15736 Date: N/A

Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue	KJ/DD	7
	•			

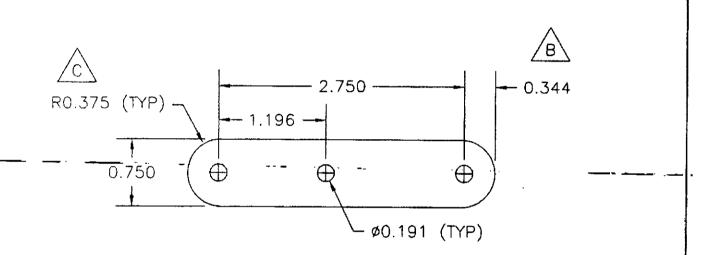
		. •	
•			





DESIGN	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
CHECKED	1 240	DRAWING NO. D2366	REV. C SHEET 1 OF 1							
DATE		TITLE	SCALE							
00.04.	24	LOCK HANDLE	1:1							
Α	95.02.20	NEW ISSUE	··							
8	96.06.10	R0.50 WAS R0.354;	0.344 WAS 0.300							
С	00.04.24	R0.375 WAS R0.50								





MATERIAL: AISI 304/316 SS 0.040 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSION ARE INCHES

Copyright @ 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

		·
		.
		· .
	``	